Work Order ID 71552

Wednesday, July 06, 2011 11:57:27 AM

Item ID: D2571 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Saddle, Fwd Out 205

Start Date: 7/6/2011 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 7/15/2011 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2571	Rev E								
100	HAAS CNC VERTICAL MACHINING #1	0.00				4	0		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program Batch No. 71552 Double check by: B.A 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect								
110	CONVENTIONAL MILLING MACHINE	0.00				4	0		
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	Machine keyway as per dwg D2571 & D2572								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				4	0		
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 71552

Wednesday, July 06, 2011 11:57:27 AM

Item ID: D2571 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Saddle, Fwd Out 205

Start Date: 7/6/2011 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 7/15/2011 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check	0.00	BA 11/07/12			4	ϕ		
	Memo	0.00							
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				H	BR 11-7-12		
	Memo	0.00							
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				4X ϕ	M 11/07/12		
	Memo	0.00							

START TIME: 1:15 OVEN TEMPERATURE: 320°F

FINISH TIME: 1:45

M11745

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 71552

Wednesday, July 06, 2011 11:57:27 AM

Item ID: D2571 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Saddle, Fwd Out 205

Start Date: 7/6/2011 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 7/15/2011 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				4	0	BR	11-7-12
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 432	0.00							11/7/13
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							11/7/13
QC	**Memo**	0.00							
Quality Control									

ME
11-07-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 11:57:24 AM

Work Order ID: 71552

Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 7/6/2011 **Required Date:** 7/15/2011

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP: I:\02.10.02\ Re-format; Change to Dwg Rev. D & incorporated D2572\KJ\

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007 Saddle Billet		Manufactured	No			100	Each	55.0000	1	4			

Location	Loc Qty	Loc Code	
MAT042	~~3~~		
~~66967~~	~~2~~		
MAT045	52		
65383	13		
65954	4		
~~2~~ 70678	8		4
70680	30		

ork 11/07/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	71552
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

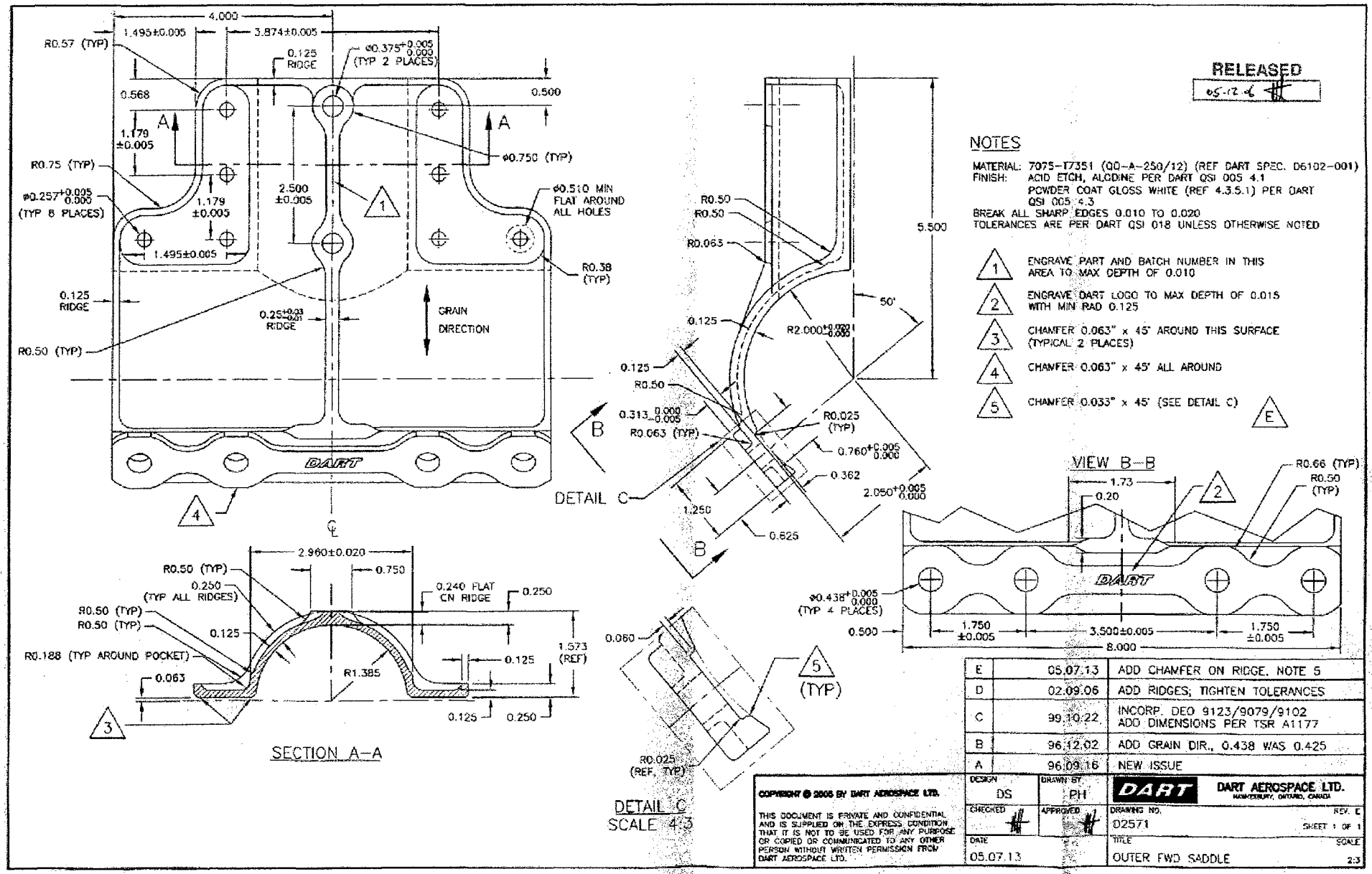
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.443	.443	.443	.440		
B	1.745	1.755		1.748	1.748	1.748	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.748	1.748	1.748		
E	7.990	8.010		8.003	8.002	8.004	8.003		
F	0.490	0.510		.501	.503	.502	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.502	.502	.501		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.567	.569	.569	.569		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.495	1.494	1.494	1.494		
N	2.495	2.505		2.499	2.499	2.499	2.499		
O	3.869	3.879		3.872	3.873	3.873	3.873		
P	0.115	0.135		.124	.125	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.249	.248	.249		
S	0.115	0.135		.130	.126	.129	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.962	2.960		
V	0.230	0.250		.240	.234	.238	.241		
W	0.115	0.135		.128	.120	.120	.125		
X	0.308	0.313		.311	.311	.309	.309		
Y	0.760	0.765		.760	.760	.760	.761		
Z	0.352	0.372		.367	.365	.368	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.626	.627	.628		
AC	0.053	0.073		.062	.062	.062	.062		
AD	0.240	0.260		.247	.243	.246	.247		
AE	1.375	1.395		1.384	1.388	1.383	1.382		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.265	.265	.265	.263		
AH	0.240	0.260		.250	.244	.248	.251		
AI	2.000	2.020		2.000	2.004	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	
Date:	11/07/07

Audited by	
Date:	11/07/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
05.07.13



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
3. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
4. CHAMFER 0.063" x 45° ALL AROUND
5. CHAMFER 0.033" x 45° (SEE DETAIL C)

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

COPYRIGHT © 2005 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN: DS	DRAWN BY: PH	DART AEROSPACE LTD. HAVERSBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2571	REV. E
DATE: 05.07.13		TITLE: OUTER FWD SADDLE	SHEET 1 OF 1 SCALE 2:3